

Date: Friday, 24/10/2008 3:31:31 PM  
User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 42946		
Estimate Number	: 11119		
P.O. Number	:	Part Number	: D30411
This Issue	: 24/10/2008 S.O. No. :	Drawing Number	: D3041 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 40493	Material	:
Written By	:	Due Date	: 07/11/2008 Qty: 30 Um: Each
Checked & Approved By	: <u>JUD 08.10.24</u>		
Comment	: Est:A 01.07.11 New Issue SM est B 07.04.09 rev.c dwg EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0875 f(s)/Unit Total : 2.6240 f(s)  
Lug Extrusion  
(D2423) Batch: B43722  
339513 c 708/10/27

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
Cut D2423 Extrusion: 1.250" Long

cut @ 4 meters

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	machine as per dwg
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Purchase



Comment: HAAS CNC VERTICAL MACHINING #1  
Machine per folio FA153

7/0.7458 c 208/10/27 (39)  
issue 7/0 4 meters

D3041 REV.C.

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

rec'd

rec'd + inspect for tensile  
damage - attached cert to w/o

28/12/27 (31)

5.0	QC2	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

28/12/15 (236)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: CLAMP

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Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(31)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/12/15

7.0 QC5 INSPECT WORK TO CURRENT STEP



M 08 12 16

(31)



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING POWDER COATING



M 10 9 15 2



(31X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00  
320 OF  
9:30

M-L 08/12/17

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



M



Comment: INSPECT POWDER COAT

08-12-17

(31X)

10.0 D2611 Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Bearing

Pick:

Qty Part Number Description Batch

1 D2611

Bearing

40518 13X B42997 18X

08/12/17

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

FF 08/12/18

(31)

12.0 QC5 INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

S 08/12/18

(31)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: CLAMP

Job Number: 42946

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



3/x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 463

8/12/18

sl

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-12-18

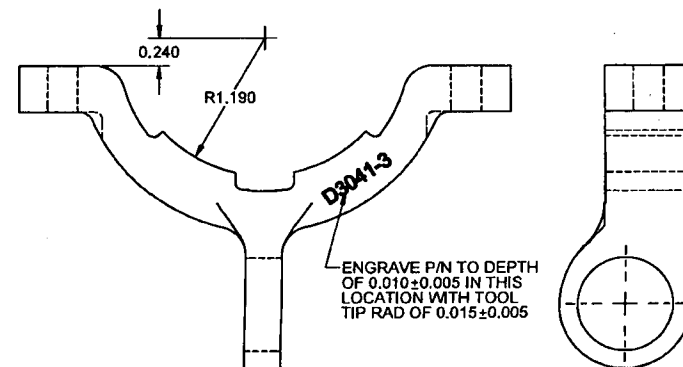
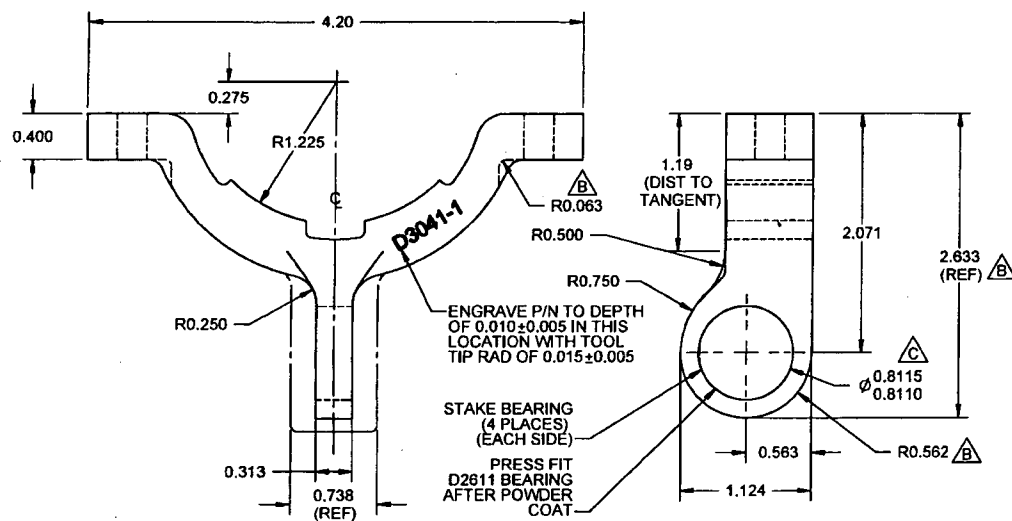
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



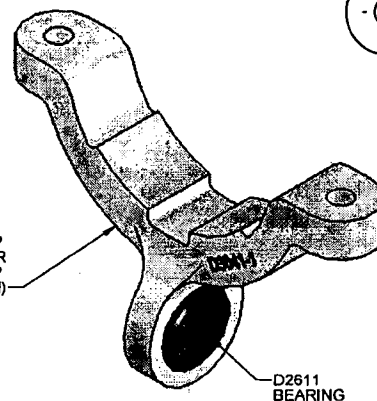
RELEASED

06.11.17

D3041-3 CLAMP  
(SAME AS D3041-1  
EXCEPT AS SHOWN)

D3041-1 CLAMP

D3041-1 CLAMP  
(SHOWN) OR  
D3041-3 CLAMP  
(NOT SHOWN)



D2611  
BEARING

- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
  - 6) STAKE D2611 BEARING AFTER POWDER COAT
  - 7) PART IS SYMMETRIC ABOUT C

C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5A-7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3041
DATE	06.10.18	TITLE CLAMP
		REV. C SHEET 1 OF 2 SCALE 1:1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

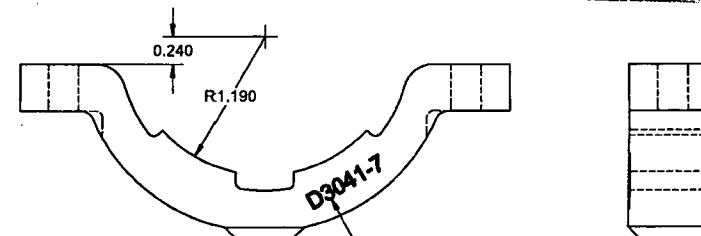
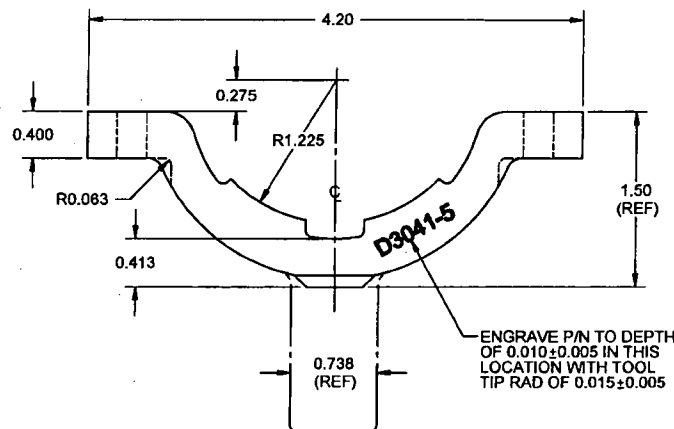
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**NOTE:** Date & initial all entries



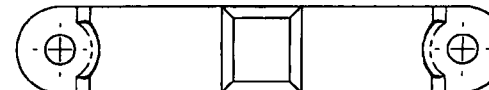
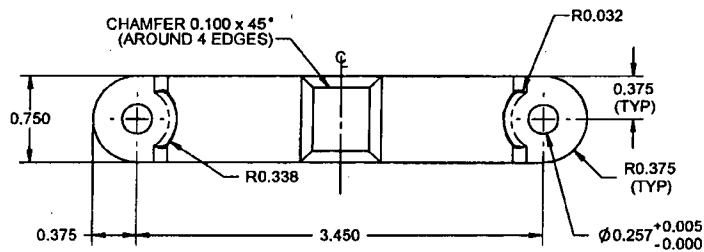
RELEASED

06.11.17



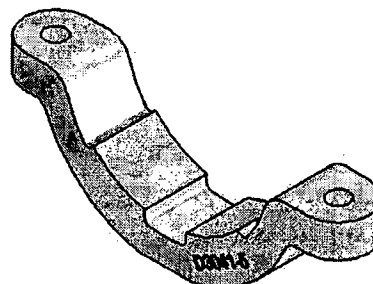
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005

ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



D3041-7 CLAMP  
(SAME AS D3041-5 EXCEPT AS SHOWN)

D3041-5 CLAMP



- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
  - 6) PART IS SYMMETRIC ABOUT C

DESIGN 07	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3041	REV. C SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP		SCALE 1:1
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries




20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:**

Date: Dec 12, 2008  
Page: 1

<b>Sold to:</b>	<b>Ship to:</b>
<b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 7458	<b>Sold By:</b> Walz, Christian D.
<b>Shipped By:</b> our truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-1 Clamp  Material supplied by DART D2423 B43722  	Each	30	31	
Received by _____		Thank you for your order!		



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

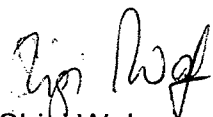
same

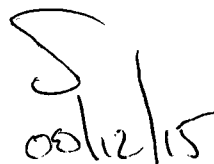
<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30	D3041-1	Lug	7458

MATERIAL: supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

  
Shigi Walz

  
0012/15

Vankleek Hill, December 12, 2008